

Date: Wednesday, 2/15/2006 3:48:38 PM  
 User: Kim Johnston

## Process Sheet

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b>	: SPACEPOD ASSEMBLY LH
<b>Job Number</b>	: 25852		
<b>Estimate Number</b>	: 10800		
<b>P.O. Number</b>	: N/A	<b>Part Number</b>	: D350600141
<b>This Issue</b>	: 2/15/2006	<b>S.O. No.</b>	: N/A
<b>Prsht Rev.</b>	: NC	<b>Drawing Number</b>	: D3186 REV A1
<b>First Issue</b>	: N/A	<b>Project Number</b>	: N/A
<b>Previous Run</b>	: 25851	<b>Drawing Revision</b>	: A1
		<b>Material</b>	: N/A
<b>Written By</b>	: <i>See comment below</i>	<b>Due Date</b>	: 3/15/2006
<b>Checked &amp; Approved By</b>	: <i>06.02.16</i>	<b>Qty:</b>	1 Um: Each
<b>Comment</b>	: Est Rev:D 05/04/14 Incorporated procedures from D3187-1/-2 K J/JLM		

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0

DC

DOCUMENT CONTROL



**Comment:** DOCUMENT CONTROL  
 Photocopy bluefile and type labels as per PPP D350-600-141 CHG002

*KJ 06.03.02*

2.0

25852A

SPACEPOD BODY LH

**Comment:** Sub-Component SPACEPOD BODY LH

3.0

25852B

SPACEPOD DOOR LH

**Comment:** Sub-Component SPACEPOD DOOR LH

4.0

D31871

Spacepod Floor



**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
 Pick:

Qty	Part Number	Description	Batch
1	D3187-1	Floor	<i>B22929</i>
1	D3186-1	Door (ref)	<i>25852B</i>
1	D3188-1	Body(ref)	<i>25852A</i>

*m/06/05/15*

5.0

ALS41032130

Insert



**Comment:** Qty.: 28.0000 Each(s)/Unit Total : 28.0000 Each(s)  
 Pick:

Qty	Part Number	Description	Batch
28	ALS4-1032-130	Insert	<i>m/18293</i>



W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD ASSEMBLY LH

Job Number: 25852

Part Number: D350600141

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Transfer drill (#30) from D3187-1. Open holes in floor to Ø0.297". Install inserts as per Dwg D3188.

*ml 06/05/17*

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*n/A pro*

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Open holes in D3187-2 as per Dwg 3187

2-Deburr D3187-2

*ml 06/05/17*

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*2005.23*

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*DL 06/06/25 (1)*

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

*a.m 06-06-26 (1)*

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*2007.04 (1)*

13.0

D2986

Black Neoprene foam .125



Comment: Qty.: 5.9010 sf(s)/Unit Total : 5.9010 sf(s)

Pick:

Qty Part Number

Description

Batch

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
	7.	QCS not required. Remove. Permanent change		<i>E</i>	06.07.13			<i>E</i> 06-05-23

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

**NOTE:** Date & initial all entries

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## Process Sheet

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Drawing Name: SPACEPOD ASSEMBLY LH

Job Number: 25852

Part Number: D350600141

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.62SF D2986

Neoprene Foam

D2986

B24628

14.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Cut D2986 Neoprene Foam per template D2986T1

2-Attach Neoprene Foam using Contact Cement

A/R Contact Cement

Batch:

M16194

SAD

06:08:04

(1)

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

16.0

D2179

Doubler



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2179 Hinge Bracket Plate

B21490

17.0

D2219

Door Prop Doubler



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2219 Door Support Bracket

B14027

18.0

D2228

Backing Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2228 Backing Plate

B14028

19.0

D2237

Striker Plate



Comment: Qty.: 3.0000 Each(s)/Unit Total: 3.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

3 D2237 Strike Plate

B24561

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
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Drawing Name: SPACEPOD ASSEMBLY LH

Job Number: 25852

Part Number: D350600141

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

D2464

3/4 Seal



Comment: Qty.: 10.9305 f(s)/Unit Total : 10.9305 f(s)

Pick:

Qty Part Number Description Batch

1 D2464-125" neoprene Seal B25153

21.0

D2586

Door Latch



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty Part Number Description Batch

3 D2586 Latch B25050

22.0

D2588

Bracket



mounting  
channel



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

~~3 D2588 Latch~~ 1 X D2588 B21509

23.0

D2589

Keys, Key Chain



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

~~1 D2588 Mounting Channel~~ 1 X D2589 B26031

24.0

D2621

Latch Plate



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty Part Number Description Batch

3 D2621 Latch Plate B25474

25.0

D28571

Hinge Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2857-1 Hinge Bracket B26033

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
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Drawing Name: SPACEPOD ASSEMBLY LH

Job Number: 25852

Part Number: D350600141

Job Number:



Seq. #:	Machine Or Operation:	Description :
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26.0	D28572	Hinge Bracket
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2857-2 Hinge Bracket B26034

27.0	D2977	Hinge Bracket
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2977 Hinge Bracket B14106

28.0	D2978	Hinge Bracket
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2978 Hinge Bracket B14107

29.0	D2982041	Prop Arm Assembly
------	----------	-------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2982-041 Prop Arm Assembly B24627

30.0	D30153	Lock Nut
------	--------	----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3015-3 Lock Nut B22365

31.0	A3235020935	Washer - Countersunk
------	-------------	----------------------



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description Batch

8 A3235-020-935 Washer M18332

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
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Drawing Name: SPACEPOD ASSEMBLY LH

Job Number: 25852

Part Number: D350600141

Job Number:



Seq. #:

Machine Or Operation:

Description :

32.0

AN526C832R9

Screw



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number Description Batch

12 AN526C832R9 Screw M15602

33.0

AN960JD10

Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty Part Number Description Batch

3 AN960JD10 Washer M19521

34.0

AN960JD516

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 AN960JD516 Washer M15927

35.0

AN960JD8

Washer



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number Description Batch

16 AN960JD8 Washer M11989

36.0

AN960JD8L

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 AN960JD8L Washer M6956

missing parts ← add on w/o Permanent

2 Rivets MS20426 AD 4-6 M2566

These parts are not in the system to follow  
or on the DWG D350-600 (p.18,19)

DWG/ICA UNDER  
REVIEW - DSI

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

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Drawing Name: SPACEPOD ASSEMBLY LH

Job Number: 25852

Part Number: D350600141

Job Number:



Seq. #:

Machine Or Operation:

Description :

37.0

MS20426AD45

Rivet



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number Description Batch

6 MS20426AD4-5 Rivet M3459

38.0

MS21042L08

Nut



Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)

Pick:

Qty Part Number Description Batch

14 MS21042L08 Nut (or -8) M15003

39.0

MS21042L3

Nut



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty Part Number Description Batch

3 MS21042L3 Nut (or -3) M15539

40.0

MS270390810

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 MS27039-0810 Screw M5865

41.0

MS27039125

Screw



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty Part Number Description Batch

3 MS27039-1-25 Screw M17570

42.0

SL69BS

Ball Stud



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 SL69-BS Ball Stud M16948

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Wednesday, 2/15/2006 3:48:39 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD ASSEMBLY LH

Job Number: 25852

Part Number: D350600141

Job Number:



Seq. #: Machine Or Operation: Description :

43.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble D3186-2 door with D3188-2 body as per Dwg ICA-D350-600

ml 06/05/17

44.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk Spacepod top surface of Pod as per Dwg D3188-2 & QSI 005 4.4

Batch: 1101266

ml 06/07/17

45.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Inspect Wing Walk

06/07/17

46.0 K10018 Spacepod Hardware Kit



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 K10018

Spacepod Hardware Kit

1322845

1 D3187-1(Ref)

Spacepod Floor

1322929

06/11/12

47.0 QC4 INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

06/07/12

48.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-600-141

Location:

PPP Rev:

06/07/12

49.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/07/13

Job Completion



06/02/13

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06-05-23	43.1	QCS req'd to inspect Assy. QCS done by [Signature] 06-05-23 permanent change [Signature]		[Signature]	06-02-13		[Signature]	[Signature] 06-05-23

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: [Signature] Date: 06/07/13  
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/05/17	43.0	The door and body don't fit well. Have to grind some spots to fit well, put glue M10008 and primer M10011 ml	[Signature]		[Signature] 06/06/14	[Signature] 06-06-14	[Signature]	[Signature] 06-06-14

NOTE: Date & initial all entries



**DART**

DESIGN #	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED CP	DRAWING NO. D3186	REV. A SHEET 1 OF 3
DATE 03.03.27		TITLE SPACEPOD DOOR	SCALE NTS
A	03.03.27	NEW ISSUE	
AI	CP # 04.11.04	NEW 4.5" WIDE UNIDIRECTIONAL	

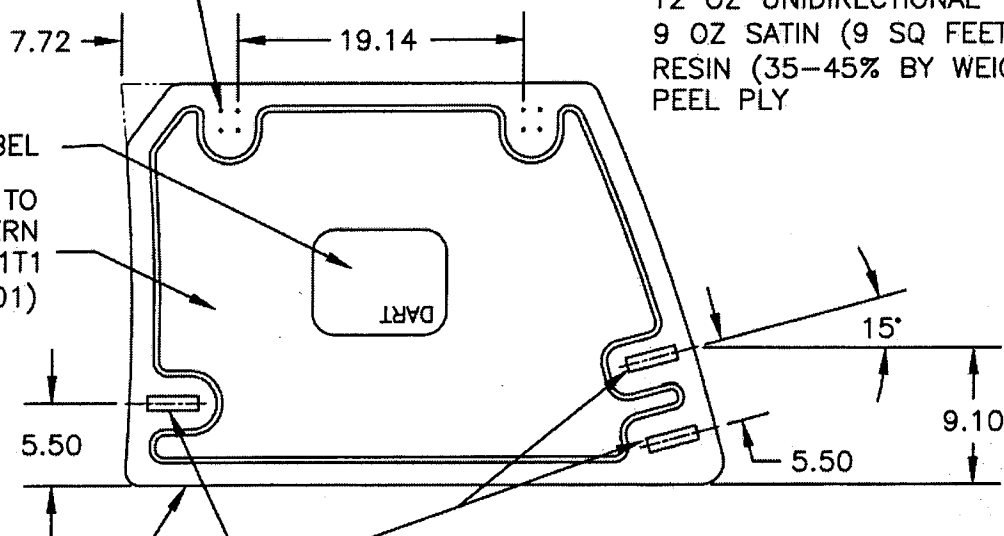
DRILL 8 HOLES  $\phi 0.171$   
PER SCRIBE LINES OF  
MOLD DT8005 (REFER  
TO DETAIL B ON PAGE 3)

**MAIN LAYUP**

9 OZ SATIN (9 SQ FEET)  
9 OZ SATIN (9 SQ FEET)  
FOAM  
9 OZ SATIN (9 SQ FEET)  
12 OZ UNIDIRECTIONAL  
9 OZ SATIN (9 SQ FEET)  
RESIN (35-45% BY WEIGHT)  
PEEL PLY

D0600-145 LABEL

ROUTER FOAM TO  
ROUTER PATTERN  
D3186-1T1  
(P/N D3186-101)



12 OZ UNIDIRECTIONAL  
4.5" WIDE 5" WIDE ALONG  
OUTSIDE EDGE

CUT 3 PLACES AS SHOWN IN DETAIL A  
ON PAGE 3

RELEASED  
#03.04.22

**D3186-1****NOTES:**

- 1) USE MOLD DT8005 FOR DOOR LAYUP
- 2) RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
- 3) FOAM: 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
- 4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")  
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 5) LAMINATE PER DART QSI 006 4.0
- 6) LAMINATION SCHEDULE PER THIS DRAWING
- 7) FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S

SHOP COPY  
RETURN TO  
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UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 25852

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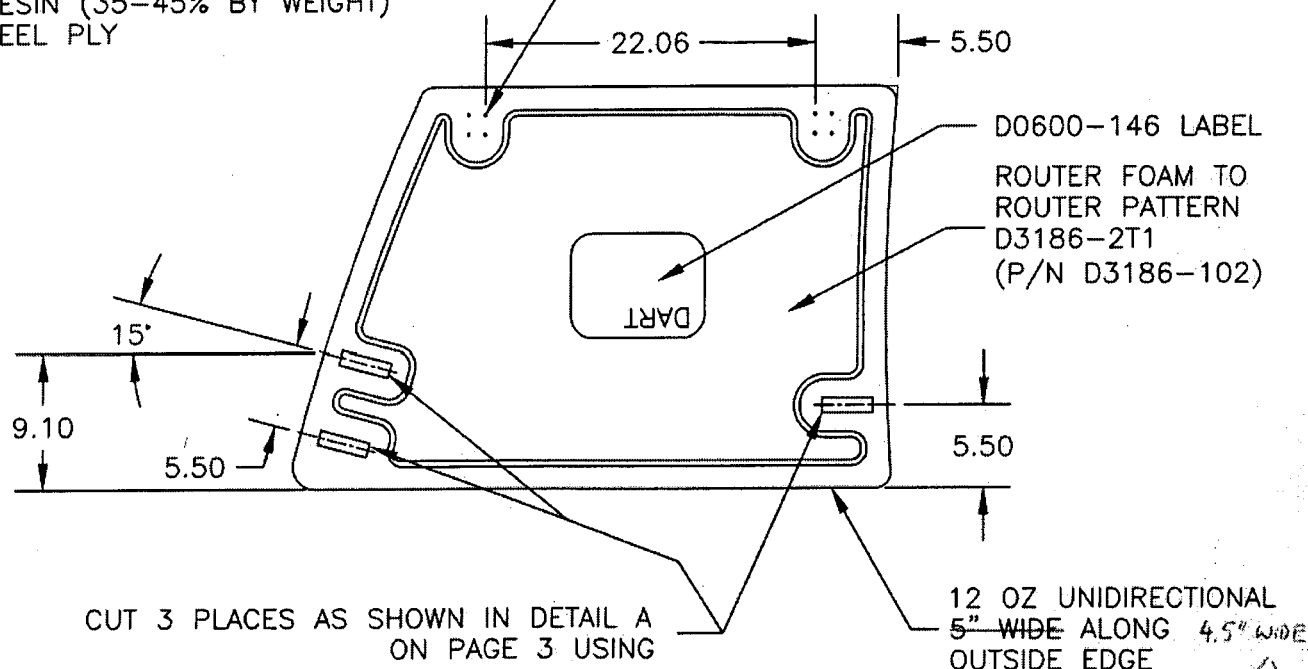


DESIGN #	DRAWN BY GP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED [Signature]	DRAWING NO. D3186	REV. A SHEET 2 OF 3
DATE 03.03.27	TITLE SPACEPOD DOOR		SCALE NTS

#### MAIN LAYUP

9 OZ SATIN (9 SQ FEET)  
9 OZ SATIN (9 SQ FEET)  
FOAM  
9 OZ SATIN (9 SQ FEET)  
12 OZ UNIDIRECTIONAL  
9 OZ SATIN (9 SQ FEET)  
RESIN (35-45% BY WEIGHT)  
PEEL PLY

DRILL 8 HOLES  $\phi 0.171$   
PER SCRIBE LINES OF  
MOLD DT8006 (REFER  
TO DETAIL B ON PAGE 3)



RELEASED  
9/03/02

D3186-2

#### NOTES:

- 1) USE MOLD DT8006 FOR DOOR LAYUP
- 2) RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
- 3) FOAM: 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
- 4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")  
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 5) LAMINATE PER DART QSI 006 4.0
- 6) LAMINATION SCHEDULE PER THIS DRAWING
- 7) FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S

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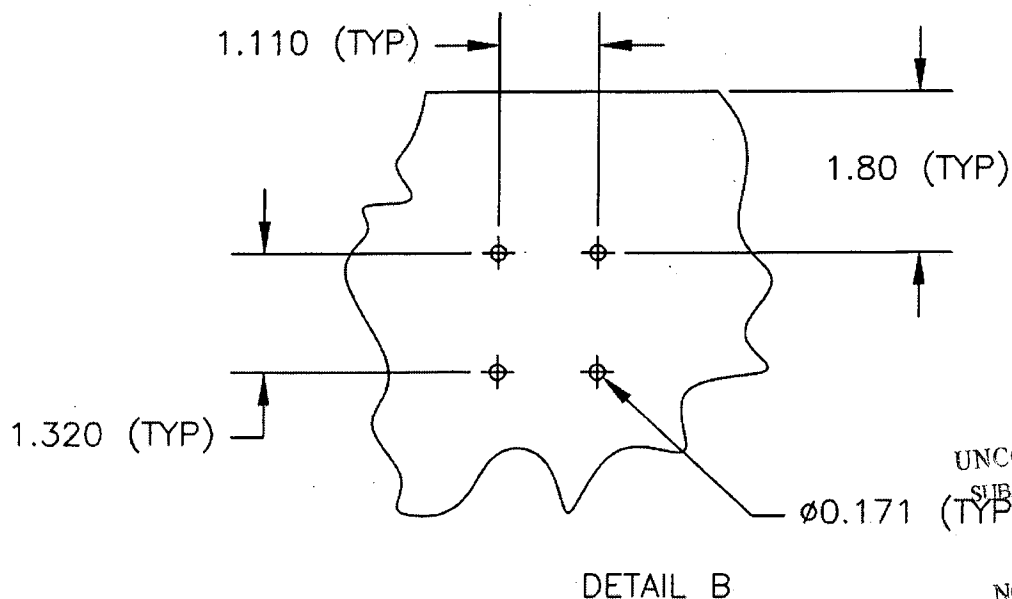
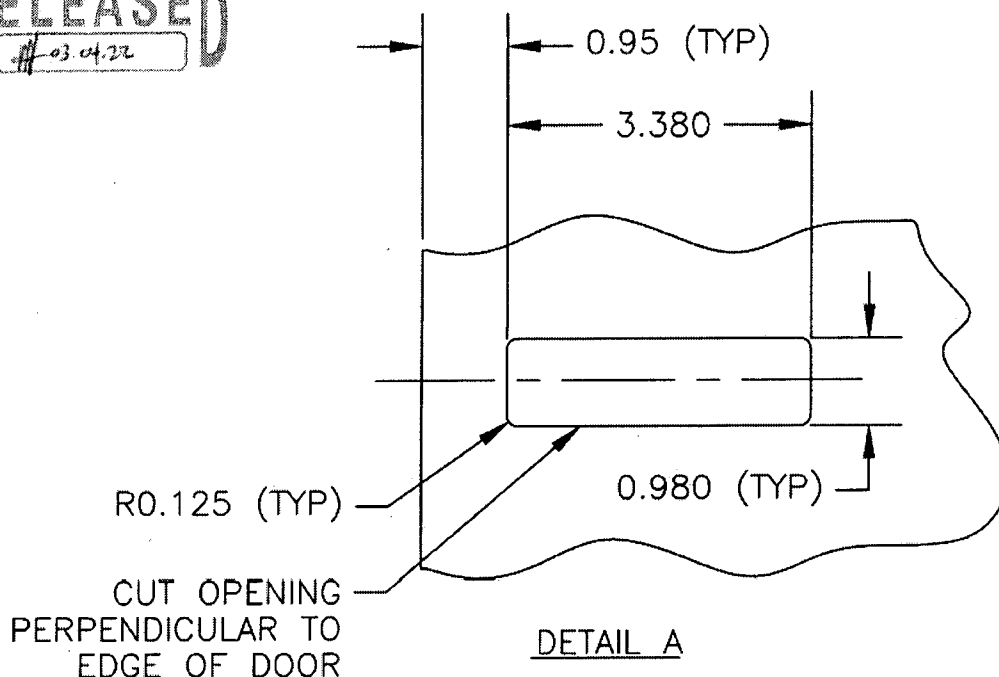
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DESIGN #	DRAWN BY GP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3186	REV. A SHEET 3 OF 3
DATE 03.03.27		TITLE SPACEPOD DOOR	SCALE NTS

RELEASED  
# 03.04.22



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